

303 500

Work Order ID 78755

78755

Page 1

January-13-12 10:45:46 AM

Item ID: D3143-1

Revision ID:

Item Name: Clevis

Start Date: 13/01/2012 Start Qty: 6.00

Required Date: 27/01/2012 Req'd Qty: 6.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: M.C.S

Date: 12/01/13 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3143

Rev B

100

0.00

100

DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Dwg D3143 and Folio FA948

Folio Rev: B

Dwg Rev: B

2-Deburr

SL 12/3/5

10 0

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

SL 12/3/5

10 0

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

SL 12-03-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78755

78755

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January-13-12 10:45:46 AM

Item ID: D3143-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clevis
 Start Date: 13/01/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 27/01/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>28</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/3/8 (x10) sl

MLJ 12/03/06

MLJ 12/03/06
(10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January-13-12 10:45:50 AM

Page 1

Work Order ID: 78755

78755

Parent Item: D3143-1

D3143-1

Parent Item Name: Clevis

Start Date: 13/01/2012

Required Date: 27/01/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.07.14 new issue DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.500		Purchased		No		100	f	389.6000	0.135	0.852632			
M303R0 500									**				
303 Round Bar 0.500"													

Location

Loc Qty

Loc Code

MAT028

389.6

117143

11.34

118271

11.9

118509

12.69

119009

243.123

119616

110.547

1.64

1213/5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	78755
Description: Clevis		Part Number:	D3143-1
Inspection Dwg: D3143	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.440	+/-0.010	0.443	/		SA-8	Uers
0.165	+/-0.010	0.170	/			
0.870	+/-0.010	0.870	/			
1.62	+/-0.030	1.633	/			
0.750	+/-0.010	0.750	/			
R0.010 _{ref}	+/-0.010	R.010	/			
0.065	+/-0.010	0.082	/			
Ø0.193	+0.005/-0.001	0.198	/			
0.660	+/-0.010	0.665	/			
0.270	+/-0.010	0.275	/			
10-32UNF-3A	N/A		/			
M.O.W. 213	+/-0.001	0.212	/		SA-5	Mic
Major Ø0.191	N/A		/			
Minor Ø0.184	N/A		/			
Major Ø	.184-.191	0.188	/			

Measured by:	SA	Audited by:	SA	Preliminary Approval:	
Date:	12/3/5	Date:	12-03-05	Date:	

Rev	Date	Change	Revised by	Approved
A	10.08.05	New Issue	KJ	SA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

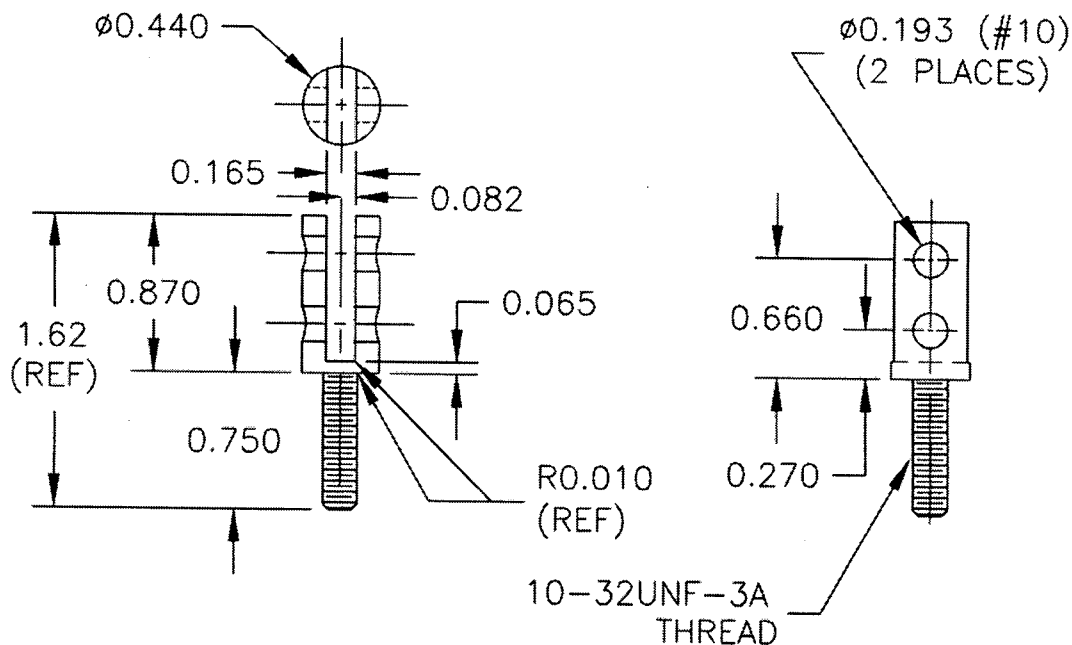
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3143	REV. B SHEET 1 OF 2
DATE 04.10.18		TITLE CLEVIS	SCALE 1:1
A	02.04.19	NEW ISSUE	
B	04.10.18	UPDATE NOTES	

RELEASED
04.11.23



D3143-1 CLEVIS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 78755 H.L.J.

12/01/13

D3143-1 NOTES

- 1) MATERIAL: ANNEALED AISI 303 SS ROUND BAR (REF DART SPEC M303R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 5) POSSIBLE SUPPLIER: PREMIER P/N B30-23000-113
- 6) IDENTIFY WITH PART P/N USING FINE POINT PERMANENT INK MARKER

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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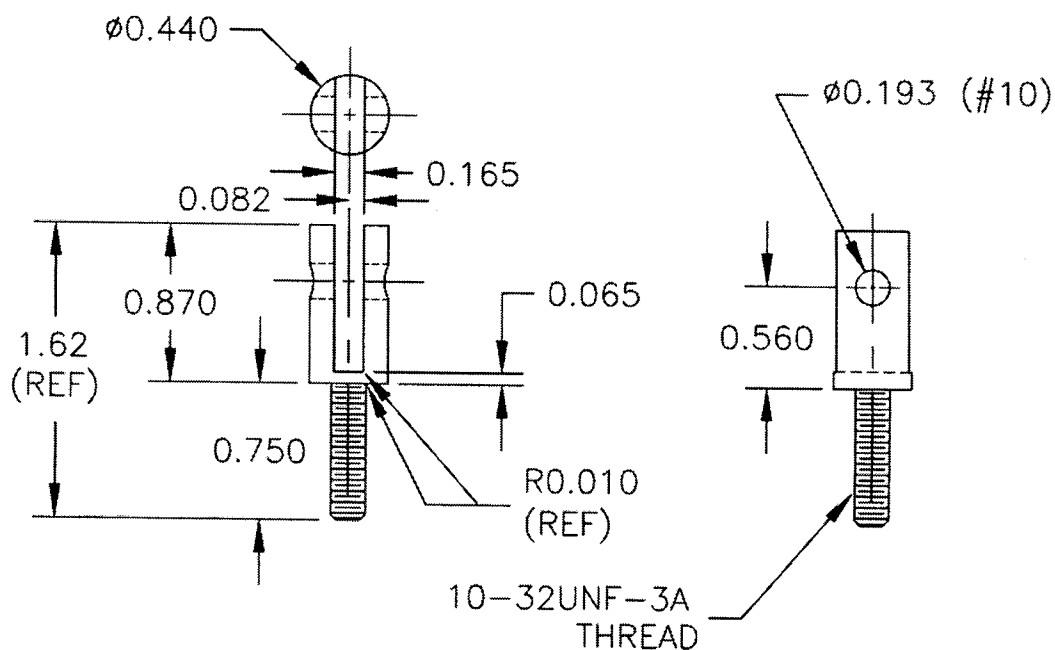
NOTE: Date & initial all entries



78755

DESIGN #	DRAWN BY LH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3143	REV. A SHEET 2 OF 2
DATE 04.10.18		TITLE CLEVIS	SCALE 1:1

RELEASED
04.11.24



D3143-3 CLEVIS

D3143-3 NOTES

- 1) MATERIAL: ANNEALED AISI 303 SS ROUND BAR (REF DART SPEC M303R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 5) POSSIBLE SUPPLIER: PREMIER P/N B30-23000-179
- 6) IDENTIFY WITH PART P/N USING FINE POINT PERMANENT INK MARKER

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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